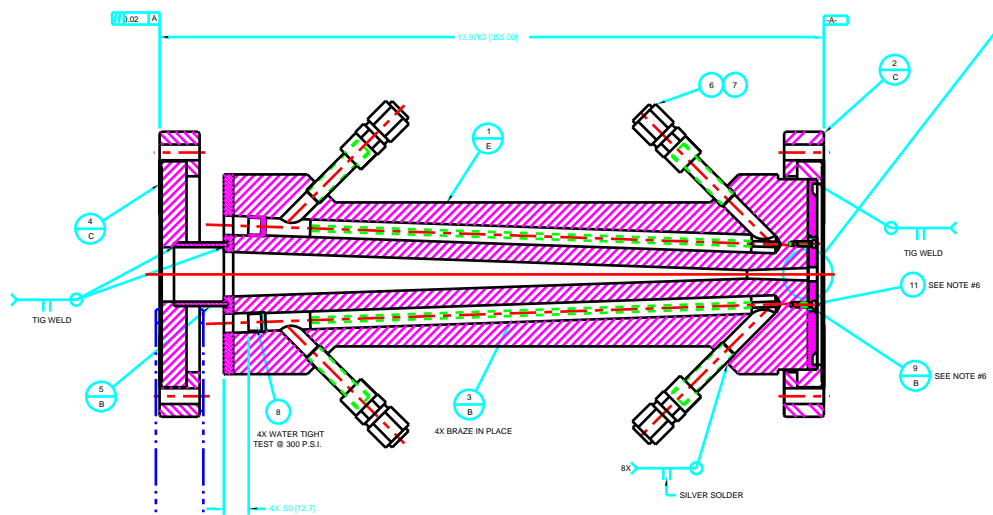
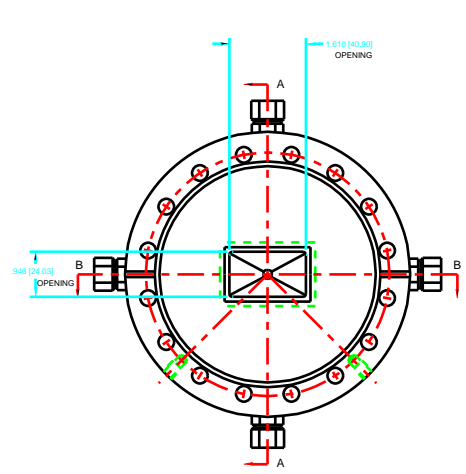
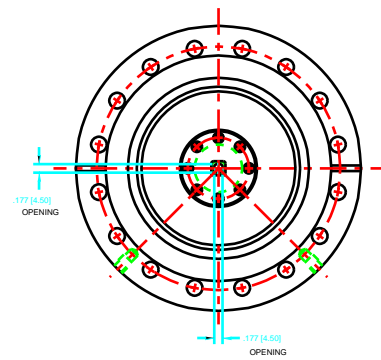


SECTION B - B



SECTION A - A



- NOTES:
1. THIS IS A UHV ASSEMBLY. ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE PART MUST GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
 2. ASSEMBLY SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2 X 10⁻¹⁰ STANDARD CC/SEC PER LEAK METER DIVISION, SUCH AS:
ALCATEL SAM-110TCL
DU PONT CEC 24-1208
VARIAN MS-9, MS-90 OR MS-18
CALIBRATION OF THE LEAK DETECTOR SENSITIVITY SHALL BE PERFORMED JUST PRIOR TO TESTING.
FINAL TEST WILL CONSIST OF SURROUNDING THE ASSEMBLY (BAGGING) WITH HELIUM. THE CHAMBER WILL BE REJECTED IF A 2% DEFLECTION ON THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 MIN.
 3. ASSEMBLY SHALL BE WATER TESTED FOR LEAKS @ 300 P.S.I.
 4. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
 5. DIMENSIONS IN [] ARE MILLIMETERS AND FOR REF. ONLY.
 6. ITEMS 9, 10, 11, & 12 ARE OPTIONAL.

REF. SOURCE

- (S)WAGLE/DK
DEARBORN VALVE & FITTING
1540 N. OLD RAND ROAD
P.O. BOX 847
WAUCONDA, IL 60084-0847
708-525-6900
FAX: 708-525-1221
- U-C COMPONENTS, INC.
410 LOGUE
MOUNTAIN VIEW, CA 94043-4019
415-964-3827
FAX: 415-964-0216
- THE LEE COMPANY
2 PETTIPAUD ROAD
P.O. BOX 424
WESTBROOK, CON. 06488-0424
203-399-6281
FAX: 203-399-7058

REV	DESCRIPTION	BY	DATE
2	P4105091505-260000 WAS	M.J.M.	
1	P4105091505-830100 WAS		
1	P4105091505-830008 WAS		
1	P4105091505-230002		
1	ITEM #13 ADDED		
1	DRAWING BROUGHT UP TO DATE	M.J.M.	

ITEM	QTY	DESCRIPTION	MATERIAL	UNIT
13	1	P4105091505-260000	LS-83 ADJUSTABLE SUPPORT ASSEMBLY	SILVER
12	1	P4105091505-830005	LS-83 CONTAM. BARRIER DIAMOND CUSHION	SST
11	1	C-405	VENTED 44-40 X 616 LG. SOCKET HD. SCREW	SST
10	1	P4105091505-230009	LS-83 CONTAMINATION BARRIER DIAMOND	SYNTHETIC DIAMOND
9	1	P4105091505-830004	LS-83 CONTAMINATION BARRIER DISC CLAMP	OPHC COPPER
8	1	PLGA4080020A	LEE PLUS	SST
7	1	600-6-6W	Ø75 X 1 1/2 LG. X .028 WALL TUBING	SST
6	1	P4105091505-830003	Ø75 TUBE SOCKET WELD UNION	SST
5	1	P4105091505-830003	LS-83 RETANGULAR EXTENSION TUBE	SST
4	1	P4105091505-230004	LS-83 LEFT END VACUUM FLANGE	SST
3	1	P4105091505-830002	LS-83 ØB COPPER MESH WITH SCREW	SST/COPPER
2	1	P4105091505-830006	LS-83 RIGHT END VACUUM FLANGE	SST
1	1	P4105091505-830001	LS-83 MAIN BODY	GLID-COP

REV	DESCRIPTION	BY	DATE
2	P4105091505-260000 WAS	M.J.M.	
1	P4105091505-830100 WAS		
1	P4105091505-830008 WAS		
1	P4105091505-230002		
1	ITEM #13 ADDED		
1	DRAWING BROUGHT UP TO DATE	M.J.M.	

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	10/22/94

DATE	10/21/94
BY	J. WOTHE
DATE	10/21/94
BY	M. KUZAY
DATE	10/25/94
BY	SHUMUSCIA
DATE	10/21/94
BY	D. SHU
DATE	1